

304 34.

Work Order ID 147880

Friday, June 17, 2016 8:24:57 AM

147880

Page 1

Item ID: D5152-5

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fwd Step Post

Start Date: 6/13/2016 Start Qty: 1200 *12*

Cust Item ID:

Required Date: 6/17/2016 Req'd Qty: 1200 *12*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: JUN 17 2016

Tooling:

Date:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D5152	B

100 0.00

100

Doosan

Doosan Lathe

DOOSAN LATHE

Memo

1- Turn as per Folio FB

Rev: AA &

Dwg Rev: B

1.76

21

φ

DAS
45
9-89

2016-6-25

110 0.00

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.02

21

φ

DAS
45
9-89

2016-6-25

Work Order ID 147880

Friday, June 17, 2016 8:24:57 AM

147880

Page 2

Item ID: D5152-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Step Post

Start Date: 6/13/2016 Start Qty: 12.00

12

Cust Item ID:

Required Date: 6/17/2016 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.04

Quality Control

DAS

14

9-89

16/06/26

150

Identify as per dwg & Stock Location: _____

0.00

150

Packaging

Memo

0.02

Packaging

LOCATION: WA002

DAS
6
9-89

21

JUL 07 2016

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.20

Quality Control

16/7/12

DAS

21

9-89

JUL 08 2016

Picklist Print

Friday, June 17, 2016 8:25:00 AM

Page 1

Work Order ID: 147880

147880

Parent Item: D5152-5

D5152-5

Parent Item Name: Fwd Step Post

Start Date: 6/13/2016

Required Date: 6/17/2016

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 15-01-08 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304RO.750		Purchased	No				f	34.1160		0.31579			

M304RO 750

304 SS Roundbar .750

Location

Loc Qty

Loc Code

MAT029

34.116

M134514

0.805

M134696

9.311

M134984

24

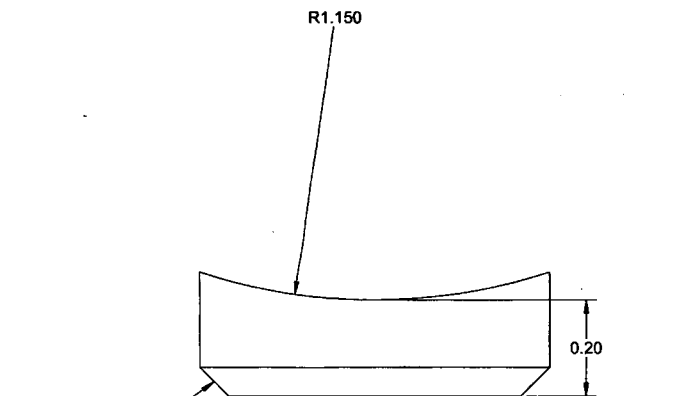
-86 PZ

DAS

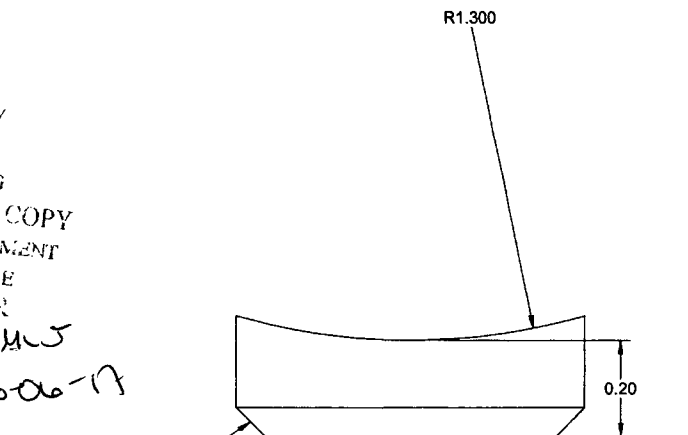
45

9-89 2ab-6-25

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
147880.MJS
1600-17



D5152-5 FWD STEP POST



D5152-7 AFT STEP POST

RELEASED

2015 FEB 09

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS ROUND BAR PER ASTM A276, REF DART SPEC M304R0.750
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.02 lbs

APPROVED

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	EPDMA		
CHECKED	DB	DRAWING NO.	REV. B
MFG. APPR.	DD	D5152	SHEET 5 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	POST MOUNT	NTS
DATE	15.01.09	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	